

Date: Friday, 23/01/2009 8:46:18 AM
User: Julie Dawson

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : JACK

Job Number : 45181

Estimate Number : 10527

P.O. Number :

Part Number : D33361

This Issue : 23/01/2009 S.O. No. :

Drawing Number : D3336 REV A

Prsht Rev. : NC

Project Number : N/A

First Issue : // Type : LARGE FAB ASSY

Drawing Revision : A

Previous Run : 43352

Material :

Due Date : 05/02/2009

Qty: 10 Um: Each

Written By : JULIE DAWSONChecked & Approved By : JULIE DAWSON

Comment : Est. A05.01.13 New issue KJ/JLM

Est. A05.12.13 Added paint EC

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING

Comment: PURCHASING

Issue P/O: 8044

For D3336-1 Jack P/N: 76508

Possible Supplier: Auto Parts Product Specification sheet is required

CLO9/01123

10

2.0

76508

JACK

Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

JACK

3.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

P-9/2/11 2

4.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Drill base of jack using DT8761 as per Dwg D3336

2-Check ram length, then tack weld as per Dwg D3336

3-Drill and Tap ram as per Dwg D3336 N/A RLC

see attached drawing from RLC
09-01-29

QTY 10 HC-12 1/4-20 UNF X 1" LONG HEX BOLT, SPAN -> B

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Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Paint base cuts to match color per dwg D3336

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

*slip to Red Barn
25 15*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

NA

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/19

Job Completion

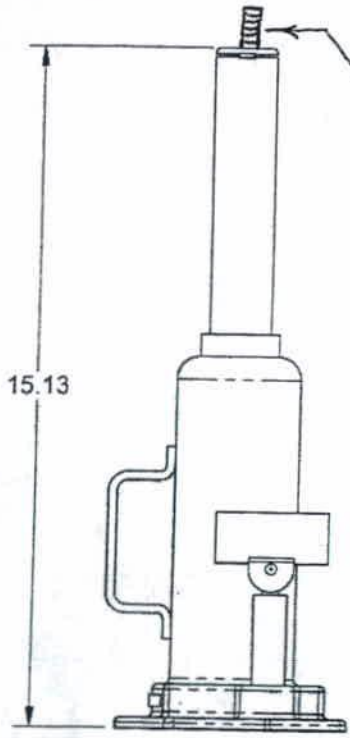


09/06/19

D3014-1
- B26021
1/4-20



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED [Signature]	DRAWING NO. D3336	REV. A SHEET 1 OF 1
DATE 04.12.16	TITLE JACK		SCALE 1:2
A	04.12.16	NEW ISSUE	



DETAIL A: SIDE VIEW
SCALE 1:4

CUT BOLT AND WELD
ON JACK
H012

1/4-20 BOLT

Cpl 09-04-29

DRILL 0.201 x 1.00 DEEP
AND TAP 1/4-20 x 0.75 DEEP
AT CENTER OF CAP.

WELD CAP WITH SHAFT
WITH 0.375 LONG
TACKS (2 PLACES)
AROUND PERIMETER

RELEASED
[Signature]
05/02/09

DRILL 0.312 PER
TEMPLATE DT8761
(2 PLACES)

COUNTER BORE $\phi 0.38$
IF NECESSARY FOR
CLEARANCE OF BOLT
HEAD (2 PLACES)

TRIM EDGES AS PER
TEMPLATE DT8761
AND PAINT CUTS TO
MATCH COLOR.

D3336-1

NOTES:

- 1) MATERIAL: 8 TONS JACK. POSSIBLE SUPPLIER: AUTOPARTS
MODEL NUMBER 76508
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
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45181

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L Lacelle

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: January 7, 2009 12:27 PM
To: 'L Lacelle'
Cc: 'Mike Petsche'; 'David Shepherd'; bbeckett@dartaero.com
Subject: RE: Hydraulic grd handling

It is ok with me, if that produce scraps the way it is now, also I check with the guys here at Eagle and said it is fine with them. Only concern with me is make sure the bolt is weld straight with shaft and have good solid weld between cap of the jack and bolt and the thread shown after nut be max. 1/4" and may be add a lock washer. This will required to update assembly drawing.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 07, 2009 7:44 AM
To: 'Roberto Fuentes'
Cc: 'Mike Petsche'; 'David Shepherd'; bbeckett@dartaero.com
Subject: RE: Hydraulic grd handling

Forgot to include attachment... sorry

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 7, 2009 9:42 AM
To: 'Roberto Fuentes'
Cc: 'Mike Petsche'; 'David Shepherd'; bbeckett@dartaero.com
Subject: Hydraulic grd handling

Hi all,
Carl had a grwat idea, to save time and parts, please see attached.
We sometimes break the cap part of the jack, by cutting off the head of the bolt and welding it on, it would take less time and make less scrap...
Let me know what you's think.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd



**AUTO PARTS • PIÈCES D'AUTO
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Past due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.
TERMS: Payment due on 10th day of the following month.

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TERMES: Compte payable le 10 du mois suivant.

SIGNATURE _____

1000 RUE LANDSDOWNE HAWKESBURY, ON K6A 1H7
TEL: (613)632-1191 FAX: (613)632-2350

TVQ
1016330716 TQ0001

GST / TPS
10035 3366 RT0001

Promotion cardans AC Delco-Cartes cadeaux Tim Hortons du 15 janvier au 15 avril 2009. recevez \$5 cartes cadeaux TIM a chaque achat d'un cardan AC DELCO.

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DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

EXP
SHIP
TO
A

113336

*** SAME ***

DATE: 2/11/09
13:44
112 MLP

00008044

ORD / COM	SHIP / EXP	CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN	COST / COÛTANT	EXTENSION			
2	2	G2S	NOR76508	bottle jack		134.00	268.00			
			de g2s				0.00			
			# in168196				0.00			
	2	***	SHIP VIA	PIECES/CORE TOT REGULAR	0.00					
INVOICE No / FACTURE				TYPE / SORTE	TOTAL	DISC / ESC	FRT / TRANS	GST / TPS	PST / TVQ	AMT to PAY / À PAYER
11926516				INVOICE	268.00	0.00	0.00	13.40	0.00	281.40